

Date: Tuesday, 30/09/2008 10:28:03 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: END CAP
Job Number	: 42354		
Estimate Number	: 13262		
P.O. Number	:	Part Number	: D301711
This Issue	: 30/09/2008 S.O. No. :	Drawing Number	: D3017 REV. A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	:	Material	:
Written By	:	Due Date	: 07/10/2008
Checked & Approved By	: <u>UMF 08-09-30</u>	Qty:	16 MF 8 Um: Each
Comment	: Est Rev:A 08-04-14 now on water jet DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NS049	4130 Sheet .049
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Comment: Qty.: 0.0042 sf(s)/Unit Total: 0.0336 sf(s)

Material: AISI 4130N Sheet, 0.049" thick

(M4130N-S049) Batch: 11612 B 8-10-2

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3017

Dwg Rev: A B 8-10-2Prog Rev: 1

2-Deburr if necessary

08/10/08 Wn (20)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and bag with light oil (Vactra oil #2), then Stock

Location: 12 8/11/09 (20)

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Drawing Name: END CAP

Job Number: 42354

Part Number: D301711

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/09 JA

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08/10-09

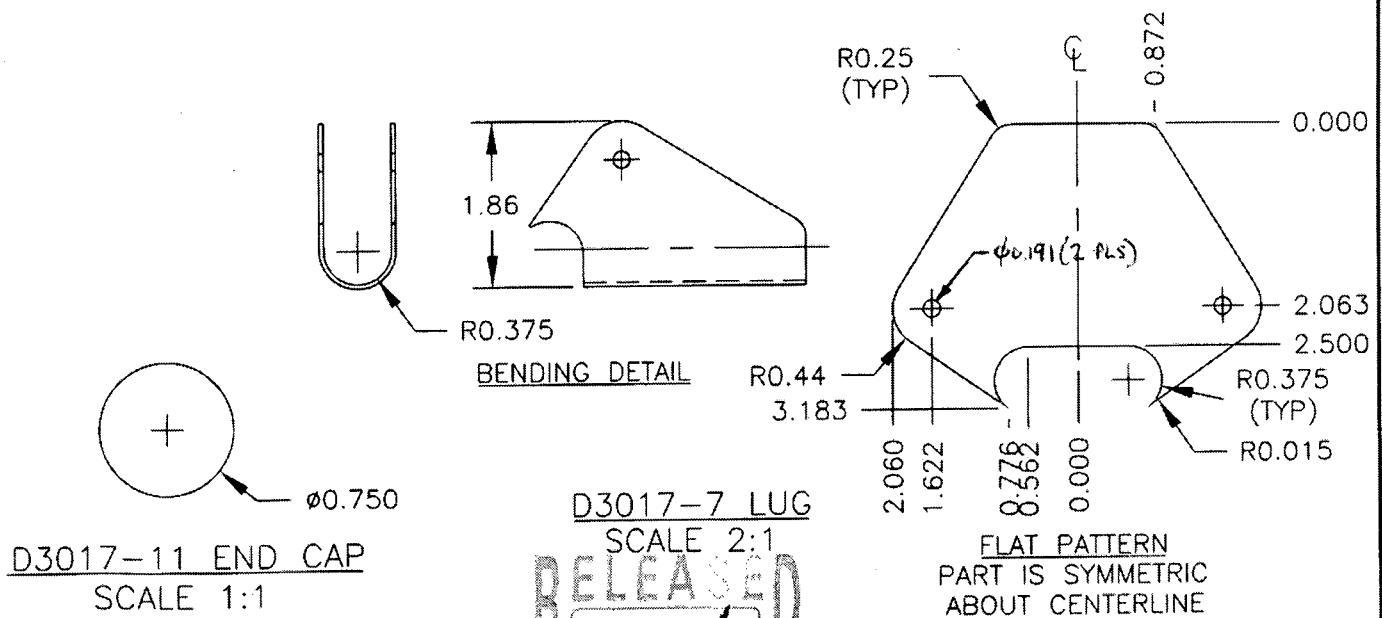


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D3017	REV. A SHEET 1 OF 2
DATE 01.05.18		TITLE BACK FRAME ASSEMBLY	SCALE 1:1
A	01.05.18	NEW ISSUE	

QTY	PART No.	DESCRIPTION	MATERIAL
X	D3017-041	BACK FRAME ASSEMBLY	N/A
1	D3017-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3017-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3017-5	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
3	D3017-7	LUG	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3017-11	END CAP	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)

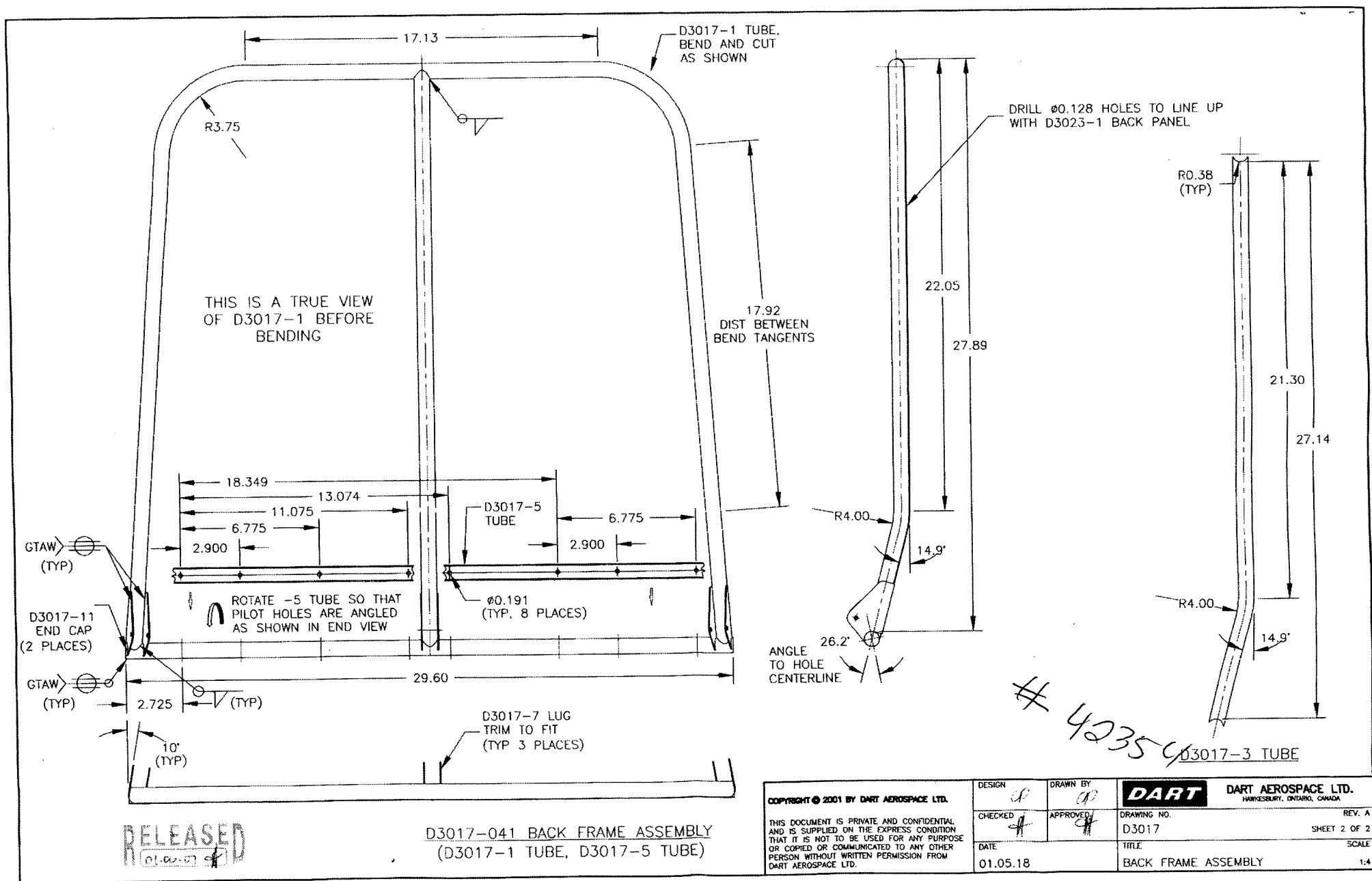
NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3017	REV. A SHEET 2 OF 2
DATE 01.05.18	TITLE BACK FRAME ASSEMBLY	SCALE 1:4	

DART AEROSPACE LTD	Work Order: 42354
Description: END CAP	Part Number: D307-11
Inspection Dwg: D307-11, Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X

x

[illegible]

Measured by:	BS	Audited by:	o	Prototype Approval:	n
Date:	8-10-7	Date:	08/10/08	Date:	g

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

